

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (withdrawn): A thermoplastic injection molded one-piece closure for dispensing dry particulate material, the closure having an end wall bounded by a periphery and having a relatively large opening and/or a plurality of shaker openings, a flap or flaps adapted to respectively close said opening or openings, the flap or flaps each being integrally connected to the end wall by a respective living hinge spaced inward from the periphery of the end wall, each flap having a lower side and a hollow plug on the lower side for each opening in the end wall associated with the flap, the hollow plug or plugs each being arranged to seal an associated opening when the respective flap is in a closed position adjacent the end wall and permit dispensing through the associated opening when the respective flap is in an open position where it is rotated about the associated hinge from said closed position, the plugs and apertures being precision molded relative to one another by surfaces carried on the same mold side.

2. (withdrawn): A closure as set forth in claim 1, wherein said plug or plugs are dimensioned to provide a touch fit seal with their associated apertures.

3. (withdrawn): A closure as set forth in claim 1, wherein said aperture or apertures have tapered surface boundaries such that the apertures are smaller in size with distance from an upper side of the end wall whereby the plugs are adapted to avoid frictional resistance with said apertures until a respective flap is near its closed position.

4. (withdrawn): A closure as set forth in claim 3, wherein said end wall has an inner surface and said aperture or apertures have a minimum size adjacent said inner surface of said end wall.

5. (withdrawn): A closure as set forth in claim 1, wherein said aperture or apertures are configured to seal between inner and outer surfaces of said end wall and such sealing is effected in an area with a height that is substantially smaller than the thickness of said end wall.

6. (withdrawn): A closure as set forth in claim 1, including a cylindrical skirt depending from said end wall, said skirt being internally threaded for screwing onto a complementarily shaped neck finish of a container.

7. (withdrawn): A closure as set forth in claim 1, wherein said plug or plugs are hollow wall structures extending from a respective flap in a substantially perpendicular direction from said flap.

8. (withdrawn): A closure as set forth in claim 1, wherein said plug or plugs are hollow formations having relatively thin walls, said walls having interior and exterior tapers.

9. (withdrawn): A closure as set forth in claim 8, wherein said plug or plugs have a length that is several times the thickness of their wall.

10. (withdrawn): A closure as set forth in claim 1, wherein the length of said plug or plugs is approximately equal to or slightly greater than the wall thickness of the end wall.

11. (withdrawn): A package comprising a bottle having a neck finish, a cap comprising a thermoplastic injection molded one-piece closure for dispensing dry particulate material, the closure having an end wall bounded by a periphery and having a spoon opening and/or a plurality of shaker openings, a flap or flaps adapted to respectively close said opening or openings, the flap or flaps each being integrally connected to the end wall by a respective living hinge spaced inward from the periphery of the end wall, each flap having a lower side and a hollow plug on the lower side for each opening in the end wall associated with the flap, the hollow plug or plugs being arranged to seal an associated opening when the respective flap is in a closed position adjacent the end wall and permit dispensing through the associated opening when the respective flap is in an open position where it is rotated about the associated hinge from

said closed position, the plug or plugs and aperture or apertures being precision molded relative to one another by surfaces carried on the same mold side, the cap having a peripheral portion structured to couple with the bottle neck finish, and a shrink wrap band applied to the exterior of the cap and bottle and shrunk in position to envelope at least portions of the flap or flaps of the cap and maintain the same in a closed position until broken.

12. (currently amended): A method of making one-piece dispensing closures comprising:

providing tooling elements that, when closed, collectively form a mold cavity defining the shape of the closure, the tooling elements being assembled on one or the other of a pair of platens, one platen being movable relative to the other, the cavity being arranged to form an end wall with at least one dispensing aperture and at least one flap integrally hinged to the end wall at a location inwardly from a periphery of the end wall and having a plug registerable with each aperture as a pair when the flap is closed over the end wall, each aperture and plug pair being formed by tooling elements on a common platen whereby precise location of each plug with respect to its paired aperture is achieved,

wherein each aperture has a tapered surface boundary such that the aperture is smaller in size with distance from an upper side of the end wall whereby the plug is adapted to avoid frictional resistance with the aperture until a respective flap is near its closed position,

wherein the flap is releasably held in closed positions by two or more depending catches that interact with complimentary receiving areas on the end wall, the two or more depending catches being separate devices that are distantly positioned from the plug.

13. (original): A method as set forth in claim 12, wherein the mold cavity tooling elements are configured to produce a touch seal between the plug and aperture.

14. (original): A method as set forth in claim 12, wherein the mold cavity tooling elements are configured to form the plug or plugs as thin wall hollow structures open at ends distal from the respective flap or flaps.

15. (cancelled).

16. (previously presented): A method as set forth in claim 12, wherein the plug has thin plug walls, and wherein exterior surfaces of the plug walls are slightly divergent, having interior and exterior tapers.

17. (new): A method of making one-piece dispensing closures comprising:
providing tooling elements that, when closed, collectively form a mold cavity defining the shape of the closure, the tooling elements being assembled on one or the other of a pair of platens, one platen being movable relative to the other, the cavity being arranged to form an end wall with at least one dispensing aperture and at least one flap integrally hinged to the end wall at a location inwardly from a periphery of the end wall and having a plug registerable with each aperture as a pair when the flap is closed over the end wall, each aperture and plug pair being formed by tooling elements on a common platen whereby precise location of each plug with respect to its paired aperture is achieved,

wherein each aperture is bound by a tapered surface characterized by an exaggerated draft-like configuration so that the aperture is widest adjacent an upper surface of the end wall whereby the plug is adapted to avoid frictional resistance with the aperture until a respective flap is near its closed position,

wherein the flap is releasably held in closed positions by two or more depending catches that interact with complimentary receiving areas on the end wall, the two or more depending catches being separate devices that are distantly positioned from the plug, and

wherein the plug has thin plug walls, wherein exterior surfaces of the plug walls are slightly divergent, having interior and exterior tapers.